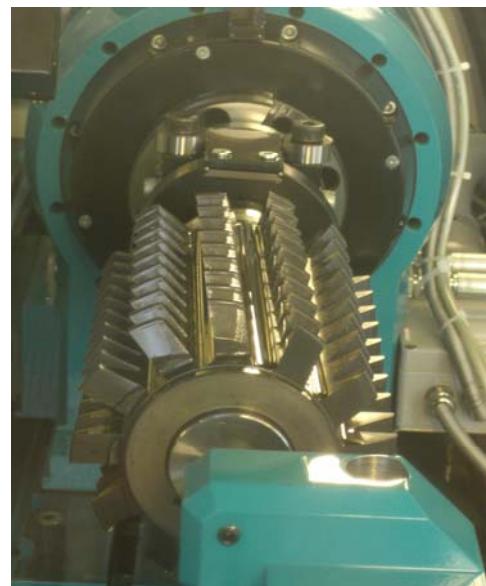
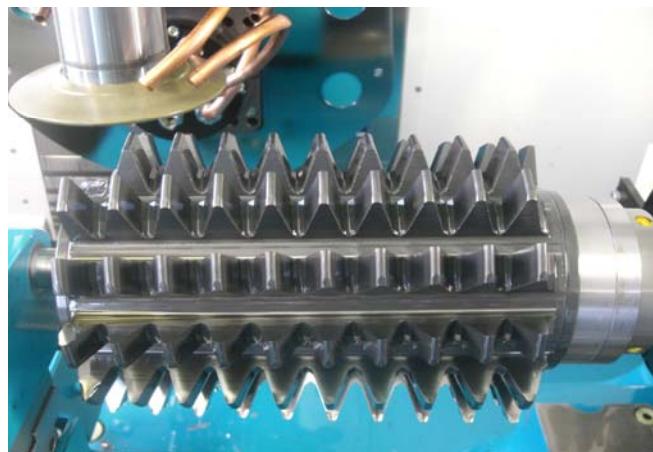


Gear Hob Ø125 Z14

A12-020

The specified cycle guarantees an excellent surface finishing (R_a less than 0,2) and the grinding operation itself leads to the best results in terms of geometric requirements such as rake angle, rake offset, indexing and helix, all of which can be easily checked without unclamping the part by means of the in-built 3D probe



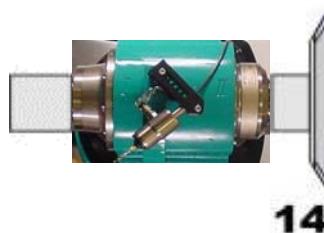
1. Cycletime for Resharpening

Tool specifications				
$\varnothing 70$ mm, Z20, Grinding Length 200 mm, Gash Lead Angle 3.5°				
Material HSS				
Operations				
Feed [mm/Min]	2000	100	2000	1000
Power [kW]		4	2	2
Cutting feed [m/s]		12	36	36
Used wheels				
Grinding time [s]	139	144	393	273
Total cycle time	15 Min 48			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

14 1V1 Ø150 B76



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, Dressing Unit (Diamond Metalbonding), A-Rapid
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

responsible engineer: OP,9.4.09

www.schneeberger.ch

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TECHNOLOGY
FOR TOOLING